Work Order Thursday, August											·	Page 1
Item ID: I Revision ID:	D3574-6			Accept	11211141 414 1411 4411 4411				Setup	Start		
Item Name:	Cabin Floor Pr	rotector								Stop		
Start Date: { Required Date: { Reference:	3/19/2010 3/23/2010	Start Qty: 2.00 Req'd Qty: 2.00			Cust Item I Customer:	D:						
Approvals:	Process Plan	n: M	Date: 10-8-10	Tooling:	Da	ite:]	Run	Start		
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center ID		Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr				, , , , , , , , , , , , , , , , , , , ,			-			
D3574	Rev	В										
100 Waterjet FLOW CNC Waterjet	t	FLOW WATER JET Memo 1-Cut as p Deburr if	oer Dwg D3574 □Dwg Re necessary	0.00 0.00 v:□Prog Rev:_	<u>R</u> []2-		-	R	10-9	-3	C	
QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00			-	<u> </u>	<u>10-9</u>	^		
120 		QC8- Inspect parts - se	econd check	0.00	50/52			(+Z	<u>)</u> —			

Quality Control

W/O:			V	ORK ORDER CHAN	GES	•						
DATE	STEP	PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			· · · · · · · · · · · · · · · · · · ·									
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _				
Resol		esolution:	ıtion: Disposition:			losed:		Date: _				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC			ection B		cation	Approval	Approval			
		Section A	Chief Eng	Action Description Chief Eng	n Sign a	Sect	ion C	Chief Eng	QC Inspector			
1			1		l l	1						

Work Order ID 61358

Thursday, August 19, 2010 1:14:17 PM



Page 2

Item ID:

D3574-6

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name:

Cabin Floor Protector

Start Date:

8/19/2010

Start Qty: 2.00

Required Date: 8/23/2010

Req'd Qty: 2.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Date: _____

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Accept

Qty

Reject Qty

Reject Number

Insp. Stamp

Work Center ID

130

Sequence ID/

Small Fab

Small Fab

Operation Description

Small Fab

Memo Deburr if necessary.

Run Hours 0.00

0.00

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Sidoglor

0.00

150

Packaging

Identify as per dwg & Stock Location: PPP

Memo

Memo

6/360

0.00

(010/3/8 2)

Packaging

W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1 Tod Wgi	
							į		
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :		_ Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCR	()			
DATE	CTED	Description of NC	Description of NC Corrective Action				ition	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
						į			
						i			
	j								

Work Order ID 61358

Thursday, August 19, 2010 1:14:17 PM



Page 3

Item ID:

D3574-6

Accept

s			s
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etup Start



Revision ID:

Item Name:

Cabin Floor Protector

Stop



Start Date:

8/19/2010

Start Qty: 2.00 **Req'd Qty: 2.00**

Operation

Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Tool #

Stop



Sequence ID/

Work Center ID

Required Date: 8/23/2010

Description

Memo

Set Up/ **Run Hours** **Tool ID**

Plan Code

Accept Qty

Reject Reject Qty Number Insp.

160

QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

0.00

W/O:	_		WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
		,							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	•
		esolution:							
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description Sign &		Verific		Approval	Approval	
DAIL	J	Section A	Initial Chief Eng	Action Description Chief Eng	Date	1 000	on C	Chief Eng	QC Inspector
	-								
		,					· · · · · · · · · · · · · · · · · · ·		
								'	

Picklist Print

Thursday, August 19, 2010 1:14:17 PM

Work Order ID: 61358

D3574-6 Parent Item:

Parent Item Name: Cabin Floor Protector

Start Date: 8/19/2010

Required Date: 8/23/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07.07.23 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			•	sf	2,704.423	33.6	67.23362			
											B10-0	1-2	

GE PLASTICS LEXAN SHEET

<u>Location</u>	Loc Qty	Loc Code	
MAT	2704.4238		-
114032	467.9238		114 033
115261	2236.5		

Page 1

W/O:			WO	RK ORDER CHAN	GES			1,1,1,1
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	·
	Re	solution:	Disposition	:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (NCF	R)		
DATE	STEP	Description of NC	Corrective Action		ction B	Verificati	ion Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section (C Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	61358
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing	Talaanaa	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø3.00	+0.006/-0.001	3,000	r		V 1807	
7.37	+/-0.030	7.37	Z		7 1361	
11.00	+/-0.030	11.00	×			
15.25	+/-0.030	15.25	Je			
25.87	+/-0.030	24,87	26			
39.75	+/-0.030	34,75	X_			•
44.75	+/-0.030	44.75	&			
58.38	+/-0.030	58,38	×			•
63.50	+/-0.030	63,50	يد			
65.25	+/-0.030	65.75	×			
10.25	+/-0.030	10.25	ير			
11.87	+/-0.030	11. 87	۵			
14.75	+/-0.030	14.74	æ			• •
26.00	+/-0.030	26.06	<i>ک</i> و			
40.87	+/-0.030	40.87	X			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	X			
55.13	+/-0.030	55,13	&-			
61.25	+/-0.030	61,25	*			
61.88	+/-0.030	61.88	&			
64.63	+/-0.030	64.63	25			
1.13	+/-0.030	1.13	> -			
7.63	+/-0.030	7,63	6			
11.00	+/-0.030	11.00	8 -			
22.10	+/-0.030	01.68	8			
22.50	+/-0.030	27.50	يخ			
24.50	+/-0.030	24.50	0			
35.13	+/-0.030	35,13	>			·
36.50	+/-0.030	36.56	Œ			
40.00	+/-0.030	40,00	a			.
41.88	+/-0.030	41.88	校			
43.63	+/-0.030	43.63	*			
6.75	+/-0.030	6.75	~			
9.50	+/-0.030	9,50	>			-

W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				•				
						,		
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	1	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
			,							
		•								
								;		
					1		,			
		parameter agency								
		•								

DART AEROSPACE LTD	Work Order: 6/358
Description: Cabin Floor Protector	Part Number: D3574-6
Inspection Dwg: D3574 Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
---	---------------	--	-----------

10.38	mments	Con	1	ethod o	1	Reject	Accept	Actual Dimension	Tolerance	Drawing Dimension
16.75			ackslash	BO	1		6	10.37	+/-0.030	10.38
16.75				`	7		7	14.50	+/-0.030	14.50
18.94 +/-0.030 19.94 17 19.00 +/-0.030 19.00 17 24.13 +/-0.030 24.13 17 33.88 +/-0.030 33.78 17 39.50 +/-0.030 39.70 17 40.25 +/-0.030 40.97 17 43.50 +/-0.030 43.40 17 46.60 +/-0.030 46.60 17					1		2		+/-0.030	16.75
19.00 17-0.030 24.13 +/-0.030 33.88 +/-0.030 39.50 +/-0.030 39.50 +/-0.030 40.25 +/-0.030 43.50 +/-0.030 43.60 +/-0.030 46.60 +/-0.030					T		يز		+/-0.030	18.94
33.88 +/-0.030 33.78 \\ 39.50 +/-0.030 34.50 \\ 40.25 +/-0.030 40.05 \\ 43.50 +/-0.030 43.50 \\ 46.60 +/-0.030 46.60 \\ 7 1					T		20	19.00	+/-0.030	19.00
39.50 +/-0.030 39.70 \times T 40.25 +/-0.030 \times T 43.50 +/-0.030 \					1		A	74.13	+/-0.030	24.13
40.25 +/-0.030 40.07 > T 43.50 +/-0.030 43.50 T 46.60 +/-0.030 4(0.60 T					7		λ	33.98	+/-0.030	33.88
43.50 +/-0.030 43.40 T 46.60 +/-0.030 46.60 T					Ť.		×	39,00	+/-0.030	39.50
43.50 +/-0.030 43.40 T 46.60 +/-0.030 46.60 T					7		7	40.25	+/-0.030	40.25
					1		A		+/-0.030	43.50
					7		n	46.60	+/-0.030	46.60
				(B 0)	V).		+/-0.010	0.125
	· ·									

Measured by:	ß	Audited by: 8	Prototype Approval:	N/A
Date:	10-9-5	Date: 10 09/07	Date:	N/A

Rev	Date	Change	Revised by	Approved =
Α	08.01.16	New Issue	KJ//DD , A	
В	09.05.15	Dimensions updated per Dwg Rev B	KJ 959	140

Dart Ae	rospace	e Ltd							K
W/O:			W	ORK ORDER CHANGE	S				
DATE STEP		PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #: esolution:							
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description Chief Eng Chief Eng		Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
				;					
								(2) (2) (4)	

61358 22.10 22.50 24.50 35.13 36.50 40.00 41.88 43.63 REF 7.37 10.25 11.00 11.87 14.75 15.25 26.00 С 25.87 С R1.50 2 PL Ø3.00 TYP 39.75 40.87 - \oplus 45.00 -44.75 \oplus 48.00 --- R200.0 55.13 - \oplus 58.38 61.25 --61.88 64.63 65.25 0.125 _ R0.25 REF 6.75 - 9.50 - 10.38 - 14.50 - 18.94 - 19.00 - 24.13 39.50 40.25 43.50 46.60 33.88 **D3574-6 CABIN FLOOR PROTECTOR**

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965

8

DESIGN	8 5-	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	45					
CHECKED (1)		DRAWING NO.	REV. B			
MFG, APPR.		D3574 SHEE	T 6 OF 6			
APPROVED	10	TITLE	SCALE			
DE APPR.		CABIN FLOOR PROTECTOR	NTS			
DATE 09.0	3.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFEDERATUL AND IS SUPPLIED ON THE EXPIRES CONDITION HIGH TO BE USED FOR ANY PURPOSE ON CONFED ON COMMUNICATED TO ANY OTHER PERSON HIGH TO BE USED FOR ANY PURPOSE ON FORD OWN TARROPSEAS TO	ON THAT IT IS TUCHTW			

W/O:		,	WO	RK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			14							
Part No:		PAR #:	Fault Category: NCR			NCR: Yes No DQA: Date: _				
Resolution:			Disposition	Disposition: Q/			QA: N/C Closed: Date:			
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval	
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	' Sec	tion C	Chief Eng	QC Inspector	
			-							